

WHAT IS CLAIMED IS:

1/ A vehicle seat runner comprising first and second runner elements slidably mounted relative to each other in a longitudinal direction, the first runner element comprising a fin connected to a base that is substantially perpendicular to the fin and that extends perpendicularly to the transverse direction between two side portions in connection with the second runner element, said first runner element comprising first and second sheet metal section members each having a fin wall, the fin walls of the first and second section members touching each other and being fixed together via their main faces to form the fin of the first runner element, the first section member further comprising a base wall which forms at least part of the base of the first runner element, said base wall of the first section member being connected to the fin wall of said first section member via a rounded bend which co-operates with the second section member to define a slot,

20 wherein the first runner element further comprises at least one welded reinforcing tab which spans at least part of said slot and constitutes a direct rigid mechanical connection between the second section member and the base wall of the first section member.

25 2/ A runner according to claim 1, in which said reinforcing tab belongs to one of the first and second section members and is welded to the other of said first and second section members.

30 3/ A runner according to claim 2, in which the reinforcing tab is formed by a plunged boss formed in the first section member level with said bend.

35 4/ A runner according to claim 3, in which the fin wall of the second section member is extended in the same plane beyond the base, and said reinforcing tab has its

end welded against said fin wall of the second section member.

5 5/ A runner according to claim 3, in which the reinforcing tab of the first section member passes through the fin wall of the second section member.

10 6/ A runner according to claim 3, in which the reinforcing tab of the first section member is welded to the fin wall of the second section member without addition of any filler.

15 7/ A runner according to claim 3, in which the second section member has a base wall substantially coplanar with the base wall of the first section member, the base wall of the second section member being connected to the fin wall of said second section member by a rounded bend which co-operates with the rounded bend of the first section member to define part of said slot, and said 20 second section member has an additional reinforcing tab which is welded to the reinforcing tab of the first section member.

25 8/ A runner according to claim 1, including a runner latch crimped between two side flanges parallel to the fin and belonging respectively to the first and second section members, the latch being crimped in the vicinity of said reinforcing tab.

30 9/ A method of manufacturing a runner according to claim 4, in which method the first and second section members are made, and then they are assembled together by welding the fin walls of said first and second section members together and by welding the end of the reinforcing tab of 35 the first section member against the fin wall of the second section member, which wall is plane.

10/ A method according to claim 9, in which the fin wall of the second section member is welded to the fin wall of the first section member and to the reinforcing tab of said first section member by laser welding by
5 transparency.